

Work Order ID 74195 RH

Tuesday, September 27, 2011 10:09:22 AM

Page 1

Item ID: D206-642-151

Accept

Setup Start

Revision ID:

Item Name: Replacement Skidtube

Stop

Start Date: 10/3/2011 Start Qty: 1.00

Required Date: 11/4/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MF Date: 11-09-27 Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3804

A

HN-ID206-642

O

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP ID206-642-151

CHG001

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

Skidtubes

0.00

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐ M117884

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

DC

11/10/07

BB 11/10/07

SAD 11-10-14

DC

11/10/17

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

SAD 11-10-18

OK 11/10/17

①

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
160 Skidtubes Skidtubes	Skidtubes Memo 1-Open holes to finished size as per Dwg D3804, (without cutting fluid) 2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid) 3-Deburr and blow out all chips from inside the tube	0.00 0.00							

11/10/18

11-10-18

11-10-18

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

1 0 BEI/10/18

180

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

BEI/10/18

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: ☒ 11-10-18 Time: ☒ 500 PMFinish Date: ☒ 11-10-19 Time: ☒ 5:30

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Sikaflex-291 ☒ M118393Sikaflex expire date: ☒ 12-5-5

SAD

11-10-18 - 0

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ND

11-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

0.00



Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐

M117884

3-Grind welds flush as per Dwg D3804.

BE 11/10/20

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐

NONE

BE 11/10/21

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

DP

11-10-22

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	HandFinishing	0.00							
	HandFinish	0.00							
Hand Finishing	Memo Install D2680-041 Nut Plate as per Dwg D3804								
215	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC	0.00							
Quality Control	Memo								
220	QC10- Inspect visual per QSI004- ground welds	0.00							
	QC	0.00							
Quality Control	Memo								

DP 11-10-22

11.10.24

5 11/10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date:	10/3/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	11/4/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
240 	Pressure Wash per QSI005 4.3	0.00							
HandFinish Hand Finishing	Memo	0.00							
250 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo	0.00							

M117745

Memo

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

1:30
320 °F
2:00

1 BK 11-10-25.

XG m-l 11/10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1RH of All 11/01/26

270

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install
plugs as per Dwg D3804. Clean excess adhesive.

1RH of All 11/01/26

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

0.00



HandFinishing

HandFinish

Memo

0.00

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R ☐ Sikaflex-291 ☐ 1111839 ☐

Sikaflex expire date: ☐ 12/05

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4 ☐

Batch: 11118988

1 RH 0 11/10/20

290

0.00



QC3- Inspect Part Finish

QC

Memo

0.00

8 11/10/27

AD

Quality Control

W/O:		WORK ORDER CHANGES					
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[illegible]

Tuesday, September 27, 2011 10:09:22 AM

[illegible][illegible][illegible]

1. **Author(s):** [Redacted]
 2. **Title:** [Redacted]
 3. **Journal:** [Redacted]
 4. **Volume:** [Redacted]
 5. **Issue:** [Redacted]
 6. **Pages:** [Redacted]
 7. **Year:** [Redacted]
 8. **DOI:** [Redacted]
 9. **URL:** [Redacted]
 10. **Abstract:** [Redacted]
 11. **Keywords:** [Redacted]
 12. **Notes:** [Redacted]
 13. **References:** [Redacted]
 14. **Comments:** [Redacted]
 15. **Other:** [Redacted]

Customer:

[illegible]

Date:

**Insp.
Stamp**

8 u/10/27

1. The first step is to identify the problem or question that needs to be answered. This involves understanding the context and the specific requirements of the task.

0.00

Quality Control

0.00

1. The first step is to identify the problem. In this case, the problem is that the company is not meeting its sales targets.

2. The second step is to analyze the problem. This involves identifying the causes of the problem and determining the impact of the problem on the company.

3. The third step is to develop a solution. This involves identifying the actions that need to be taken to address the problem and determining the resources that will be required.

4. The fourth step is to implement the solution. This involves putting the solution into action and monitoring the progress of the implementation.

5. The fifth step is to evaluate the results. This involves assessing the effectiveness of the solution and determining whether the problem has been resolved.

Packaging

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev: 11174367

0.00

0.00

Quality Control

11/11/14
mf
11-1V-10

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

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Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube



Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2620		Manufactured	No			110	Each	23.0000	1	1			
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Skidtube, 206 Skidtube

Location	Loc Qty	Loc Code
LG	23	
71616	5	
71617	6	
73781	5	
73786	3	
73787	4	

D2647		Manufactured	No			110	Each	36.0000	1	1			
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Cap

Location	Loc Qty	Loc Code
LG002	36	
55352	8	
71171	28	

CR3212-4-04		Purchased	No			180	Each	10,997.00	52	52			
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Cherry Rivet

Location	Loc Qty	Loc Code
ST311	997	
116471	78	
117816	179	
118686	1	
118840	739	
ST516	10000	
119017	10000	

11/10/11

11/10/11

11/10/11

52

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-1 Manufactured No

180 Each

12.0000 1 1



Web

Location

Loc Qty

Loc Code

LG

73794

12

73789

10

73790

2

① DP 11-10-18

D3286-1 Manufactured No

180 Each

80.0000 2 2



Doubler

Location

Loc Qty

Loc Code

LG002

80

64563

6

74111

74

②

PC 11/10/11

D2649 Manufactured No

200 Each

2,019.000 19 19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

736

68224

2

71355

2

72704

2

72841

130

73855

600

LG001

1283

65317

1

68507

11

73390

71

73857

600

73860

600

19

BEA/10/9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:09:18 AM

Work Order ID: 74195



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3286-3 Manufactured No

200

Each

98.0000

2

2



Spacer



Ben 10/21

Location

Loc Qty

Loc Code

LG001

83

74117

83

2

LG002

15

64564

15

D2680-041

Manufactured No

210

Each

40.0000

1

1



Nut Plate



Location

Loc Qty

Loc Code

LG

40

73334

40

1 11-10-22

CR3212-4-03

Purchased

No

210

Each

2,116.000

2

2



Cherry Rivet



Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1114

114859

1114

ST318

1000

119017

1000

2 11-10-22

AN960JD416

NAS1149D0463J

Purchased

No

210

Each

0.0000

1

1



Washer



M118384

(x1) ML 11/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:09:18 AM

Work Order ID: 74195

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

210

Each

1,401.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

399

117086

21

117849

378

ST317

1000

119017

1000

② 11-10-22

MS27039-4-06

Purchased

No

210

Each

29.0000

1

1



Screw

Location

Loc Qty

Loc Code

FP-A

8

115460

8

ST292

21

115460

21

M119124

X1

D2651-1

Manufactured

No

270

Each

289.0000

6

6



Plug

Location

Loc Qty

Loc Code

fpa

109

69018

109

FP-A

180

57869

1

66445

10

67760

36

70691

100

70839

2

71037

31

B73827

X6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:09:18 AM

Work Order ID: 74195



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-3 Manufactured No

270

Each

1,799.000

6

6



O-Ring



11/10/26

Location

Loc Qty

Loc Code

FP-A

1799

61962

12

66956

282

73489

505

73828

1000

X6

D3873-1 Manufactured No

280

Each

599.0000

14

14



Bushing



11/10/26

Location

Loc Qty

Loc Code

ST084

4

68247

4

ST088

595

64760

1

70690

47

71837

87

73399

60

73829

400

B 73831

X14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector*

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:09:19 AM

Work Order ID: 74195

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2646 Manufactured No

280 Each

87.0000 1



Aft Cap



1
JL 11/10/26

Location	Loc Qty	Loc Code
FP004	43	
68280	43	
FP006	5	
62678	5	
FP-4	35	
70945	1	
71070	34	
fp5	4	
71038	4	

D3805-041 Manufactured No

280 Each

0.0000 1



Wearplate Assembly Fwd, Low Gear

MS27039-1-08

Purchased No

280 Each

1,216.000 2



Screw



1
B74940 (x1) JL 11/10/26

2
JL 11/10/26

Location	Loc Qty	Loc Code
ST291	1216	
115108	16	
117423	300	
118378	400	
118910	500	

2
JL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:09:19 AM

Work Order ID: 74195

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

280

Each

8,411.000

7

7



Nut



11/10/26

Location

Loc Qty

Loc Code

ST300

2411

117441

16

117601

240

117885

155

118451

1000

118927

1000

ST516

6000

119017

6000

V7

D3805-045

Manufactured

No

280

Each

6.0000

1

1



Wearplate Assembly Aft, Low Gear



B73817 (v1) 11/10/26

Location

Loc Qty

Loc Code

FP

6

70878

6

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2



Washer

X

M117087



(x2) 11/10/26

AN3-37A

Purchased

No

280

Each

261.0000

7

7



Bolt



11/10/26

Location

Loc Qty

Loc Code

ST353

211

111668

111

118628

100

ST354

50

117619

50

V7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

Tuesday, September 27, 2011 10:09:19 AM

Work Order ID: 74195



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

280

Each

4,404.000

7

7



Handwritten: 11/10/2011

Washer

Location

Loc Qty

Loc Code

ST298

4404

117601

274

118077

1130

118612

1000

118968

2000

Handwritten: X7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

#74195

RELEASED
UP 09.03.03
per ECN 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 1 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

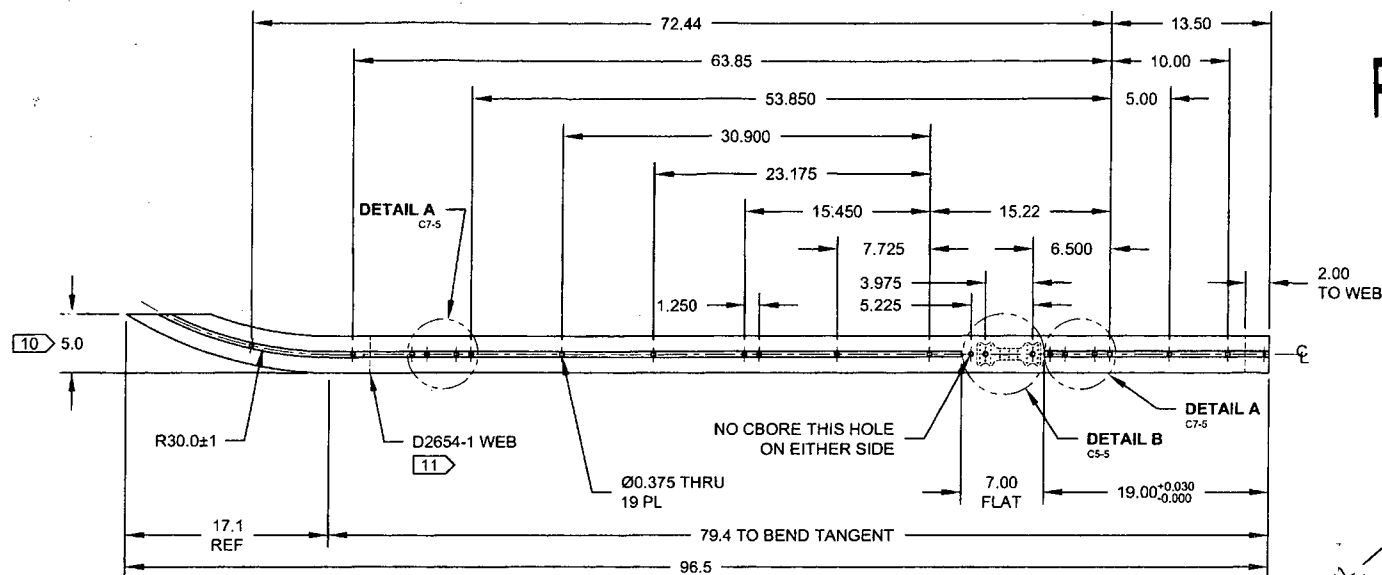
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

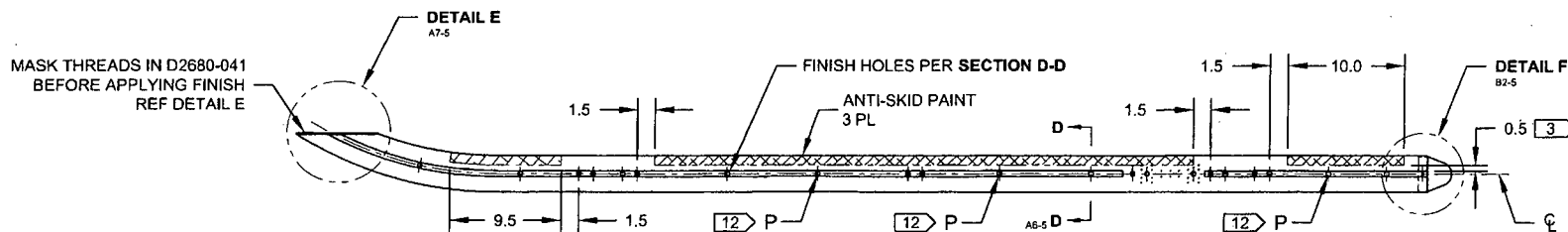
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
09.03.03



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 2 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

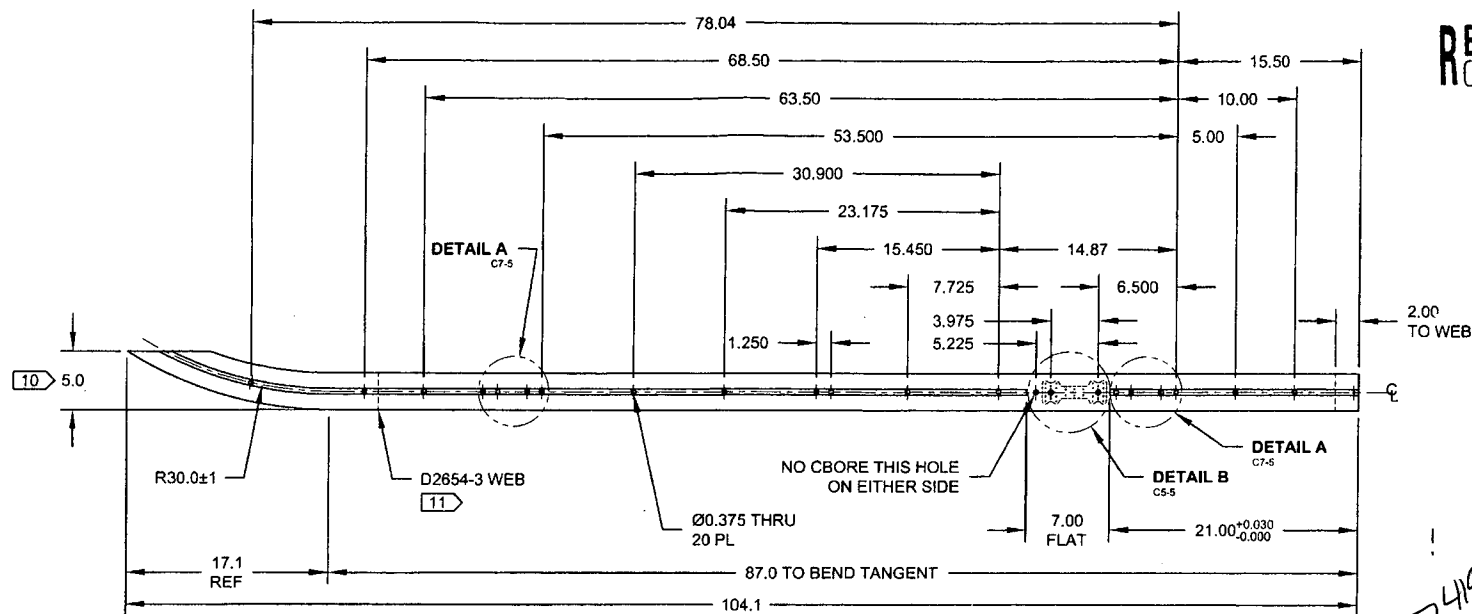
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

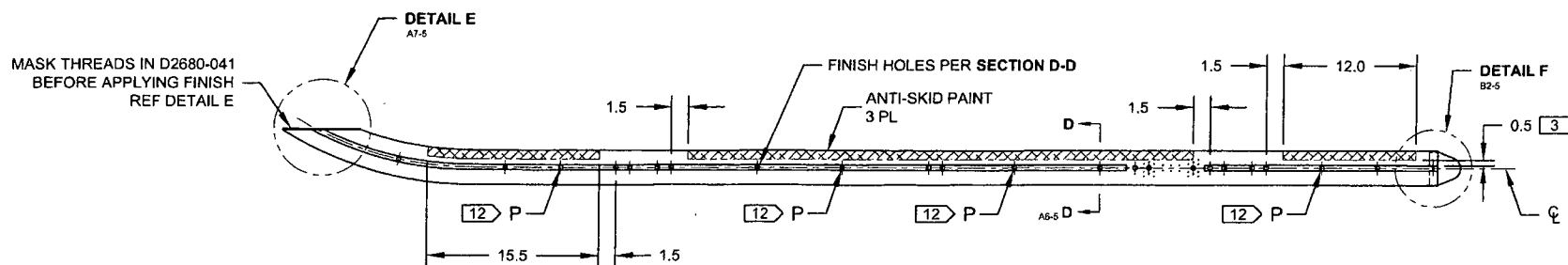
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
09.03.03



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	1	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

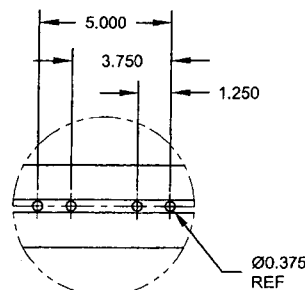
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

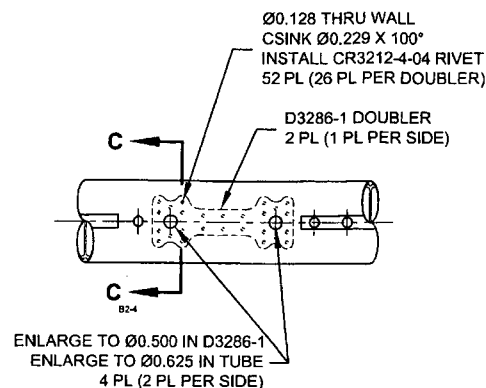
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

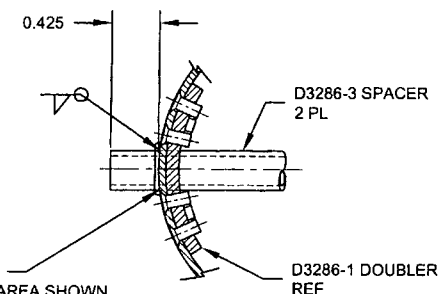
RELEASED
09.03.07



DETAIL A
D6-2
C2-2
D6-3
C2-3
SCALE NONE

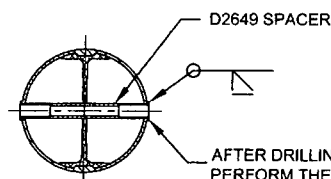


DETAIL B
C3-2
C3-3
SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
C6-4
PARTIAL SECTION
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	7	DRAWING NO.	REV. A
MFG. APPR.	8	D3804	SHEET 4 OF 5
APPROVED	9	TITLE	SCALE
DE APPR.	10	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

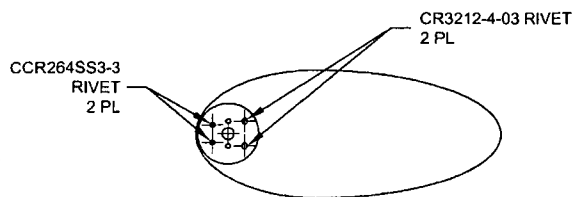
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

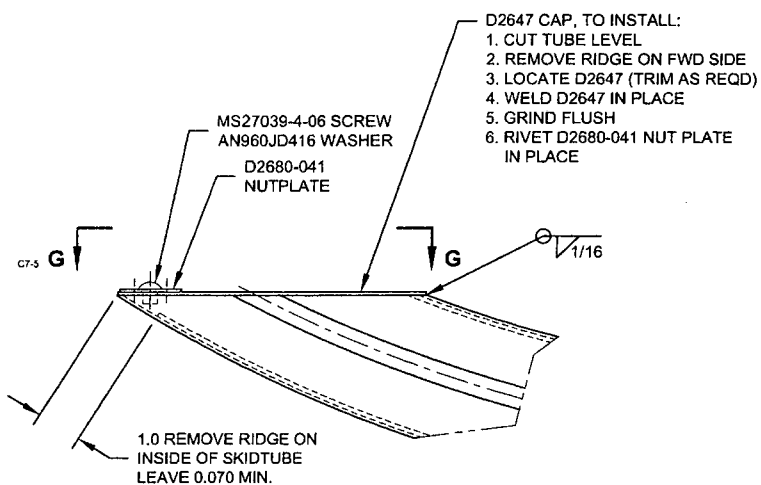
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

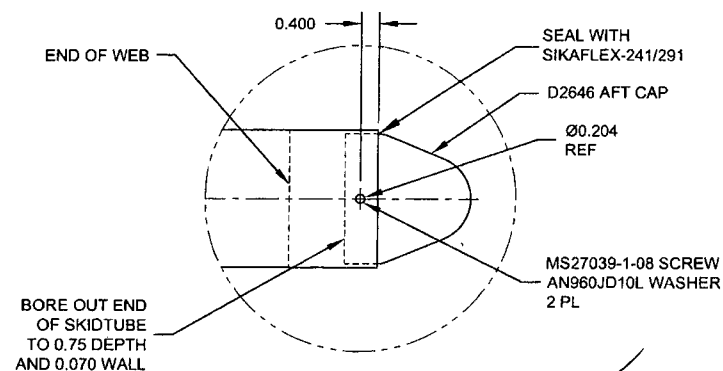
RELEASED
07 07 03 04



VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

74195

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	4	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 5 OF 5
APPROVED	4	TITLE	SCALE
DE APPR.	4	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 272

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 73871
Part number: D 206-1042-151
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Sal Dums Date of Test Coupon 11-10-12

Welder Barclay Elliott Date of Test Coupon 11-10-12

The above named individual is qualified in accordance with AWS D17.1.2001 to weld